

Work Order ID 50889

July 23, 2009 2:13:41 PM

Page 1

Item ID: D3515-041

Accept

Revision ID: A

Item Name: Basket Lid Assembly

Start Date: 7/27/09 Start Qty: 1.00

Required Date: 8/07/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3515

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut rib D3515-1 (2) as per dwg D3516 12-Cut rib D3515-3 (2) as per dwg D3516 13-Cut rib D3515-5 (6) as per dwg D3516 14-Cut rib D3515-7 (3) as per dwg D3516 15-Cut Rib (4) D2236 from D3166-3 per dwg D2236

SAD 09.07.24

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3515

09.07.24

120

0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

09.07.24

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Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 1:2-Cut expanded metal for base ends as per dwg D3516 1:3-Weld expanded metal to base as per dwg D3516

09.07.27

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

09.07.29

Work Order ID 50889



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Item ID: D3515-041
Revision ID: A
Item Name: Basket Lid Assembly

Accept



Setup Start



Stop



Start Date: 7/27/09 Start Qty: 1.00
Required Date: 8/07/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O

0.00

27 809107130

(20)

φ

QC Memo

0.00

Quality Control

170 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

1ST COAT: START TIME: 1:30pm OVEN
TEMPERATURE: 2:00pm FINISH TIME: 400°F
2:15pm ***** 2nd coat if
necessary ***** 2ND COAT: START TIME:
2:45pm OVEN TEMPERATURE: 400°F

1112148 09-07-30 (X1) JH

180 QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

BR 09-07-30 (1)

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Item ID: D3515-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Basket Lid Assembly

Start Date: 7/27/09 Start Qty: 1.00

Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00

HandFinishing

HandFinishing

Memo

0.00

Hand Finishing

Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per
dwg drawing wa [black spray paint: M11013

200

0.00

QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

210

0.00

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Packaging

AP 50888

9/5/09

@ 50

BR 09-07-31 @

2) 8 09/08/04

@

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Item ID: D3515-041

Accept

Revision ID: A

Item Name: Basket Lid Assembly

Setup Start

Stop

Start Date: 7/27/09 Start Qty: 1.00

Required Date: 8/07/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/19

MF 09-08-19

Picklist Print

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Work Order ID: 50889

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 7/27/09


Required Date: 8/07/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	2.0000	2.0000			
												
Basket Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
B50896		

D2327-1RevD		Manufactured	No			100	Each	10.0000	2.0000			
												
Spacer Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
46325	10	

D2506RevF		Manufactured	No			100	Each	6.0000	1.0000			
												
Label Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
44275	1	
48607	1	
50027	4	

Cpl 09.07.27

2 Cpl 09.07.24

1 Cpl 09.07.24

Picklist Print

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Work Order ID: 50889

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	15.0000	2.0000 			

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		23	
46086		2	
48428		21	

2 CPC 09-07-24

Main Warehouse			
WA		-8	
48428		-8	

✓ D3166-3RevA1  Basket Hoop	Manufactured	No				100	Each	3.8105	1.0000 			
--	--------------	----	--	--	--	-----	------	--------	---	--	--	--

SAD 09-07-24

Qty
1

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
WA		3.810526316	
48429		-0.9368105	
50033		4.74733684	

1

SAD 09-07-24

Qty
1

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 50889

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	482.5287	21.0526			
												
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

482.5287065

108152 90

110134 6.7

110292 14.4

110629 14.41

110861 21.18

110992 0.58

111444 17.79

111630 27.15

111956 6.335517

112147 283.983189

3.0326

18.000

M304TS0.750W.065

Purchased

No

140

f

506.9338

43.6842



304 SQ Tube .75x.75x.065W

SAD 09-07-24

SAD 09-07-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

506.9338137

111148 0.484

111432 0.44

111885 1.5682

112051 30.7574737

112263 473.68414

43.6842

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B112263 End Bar Scrap -> 2.00
Shop Packet Print

Page 3



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

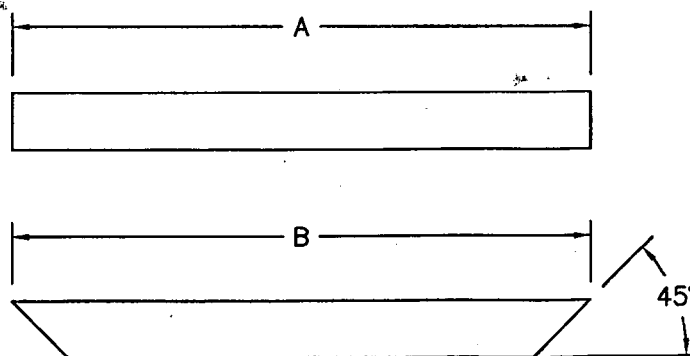
RELEASED

06.11.17 *[Signature]*

W/O Sassy

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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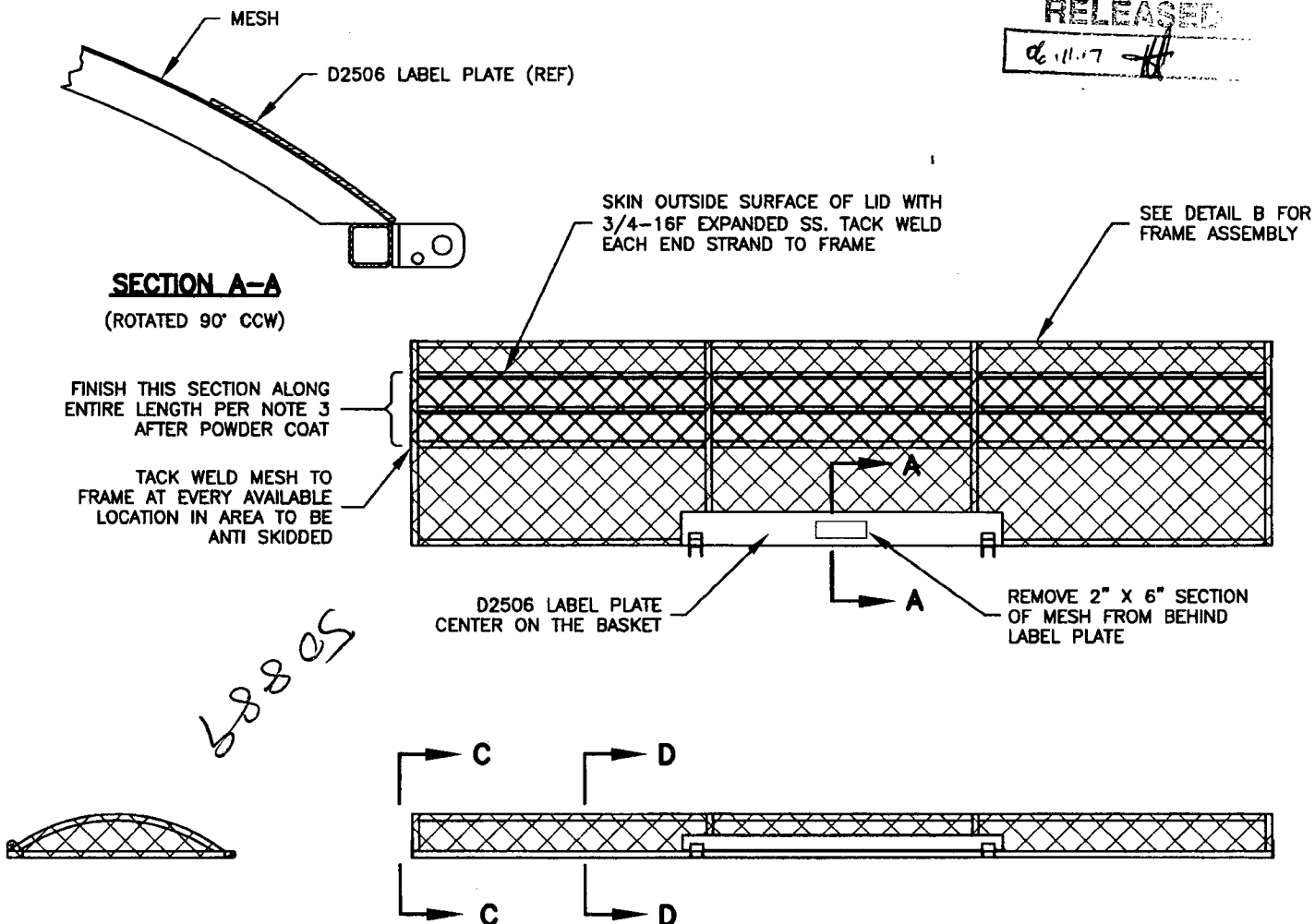
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DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		D3515	REV. A
06.05.05		TITLE	SHEET 2 OF 4
		BASKET LID ASSEMBLY (A119)	SCALE
			1:20

RELEASED

06.11.17

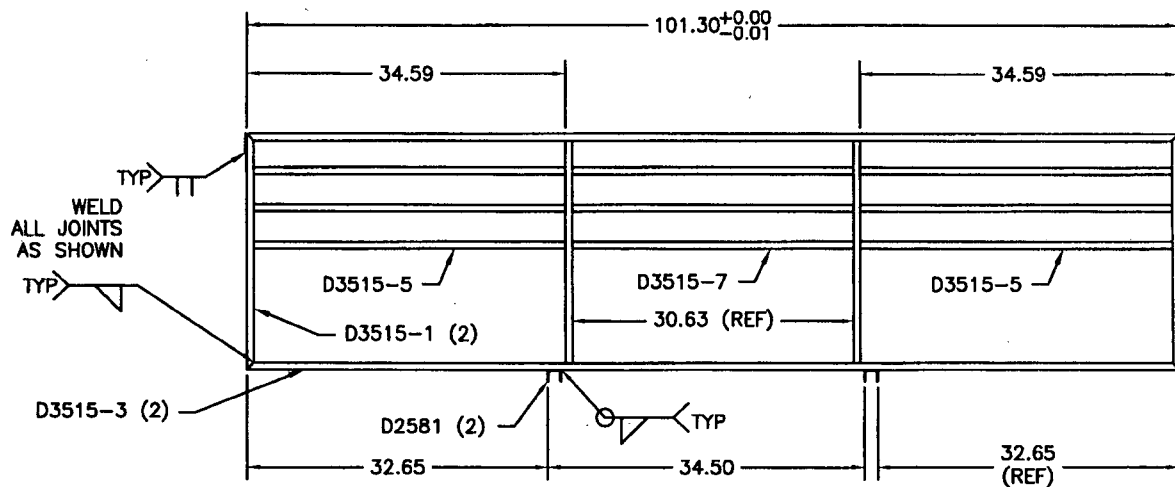


D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

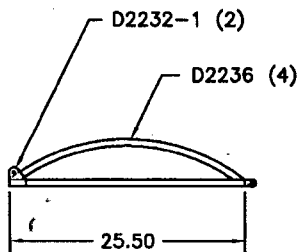
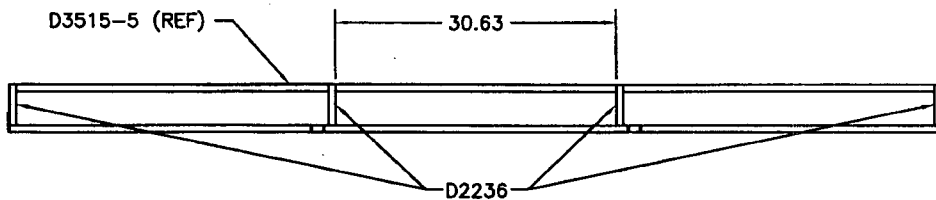
DART

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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 3 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

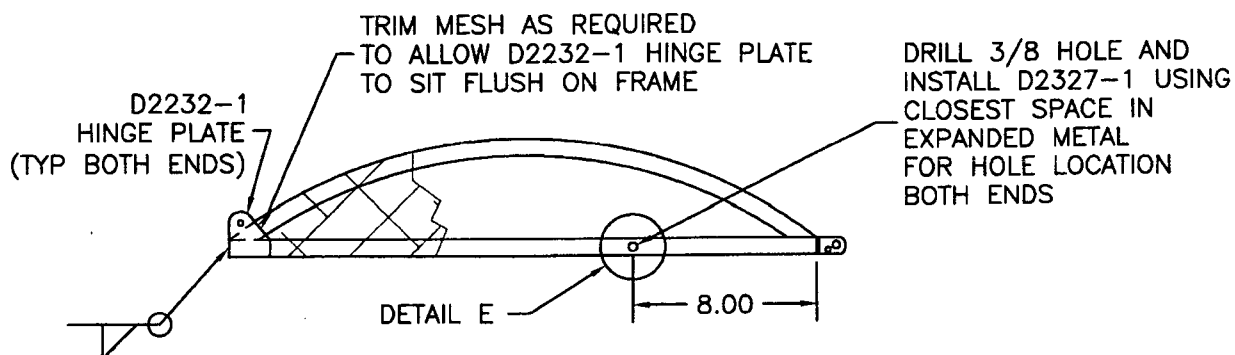


50885

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06.11.17

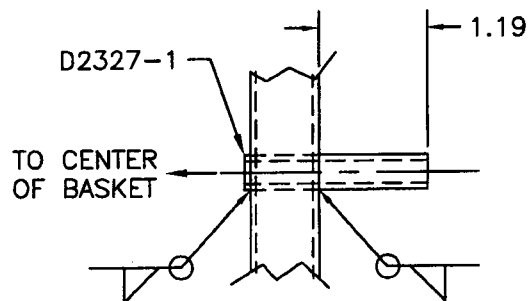


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

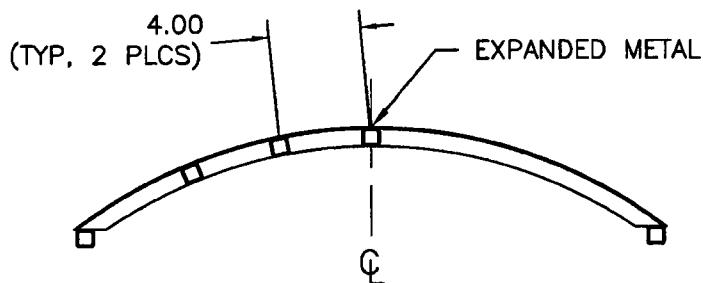


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06-11-17 H



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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